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⑯ Colored salts of polymeric sulfonate polyanions and dye cations, and light-absorbing coatings
made therewith.

⑯ Light-stable film-forming salts of a sulfonated
polymer, especially a sulfonated polyester, and a
cationic dye. When these dye-polysalts are coated
onto shaped polymeric structures, especially trans-
parent self-supporting films, the resultant products
have important optical uses. A polyester film coated
with certain red or amber blends of dye-polysalts
and provided with a pressure-sensitive adhesive
coating is useful as a lithographers' tape.

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EUROPEAN PATENT APPLICATION

⑬ Application number: **88311855.6**

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EP 0 327 763 A2

COLORED SALTS OF POLYMERIC SULFONATE POLYANIONS AND DYE CATIONS, AND LIGHT-ABSORBING COATINGS MADE THEREWITH

Background of the Invention

This invention relates to light-absorbing polymeric salts and to shaped polymeric structures, especially self-supporting films, coated therewith.

5 Photosensitive lithographic plates are readied for printing by exposing them to activating radiation through a negative, thereby rendering the exposed portions ink-receptive and the unexposed portions non-receptive in the case of a negative-acting plate, or vice versa in the case of a positive-acting plate. The higher the quality of printing desired, the more important it is to avoid exposing undesired portions of the plate to radiation. Such inadvertent exposure may occur when pinholes or other flaws exist in the negative, or when certain portions of the negative must be blocked out for use in a different printing operation. It is 10 usually necessary to achieve an absorbance of 3 to 3.5 to satisfy the lithographic preparator. An early attempt to solve this problem involved "painting," with a radiation-obscuring composition, the portions to be blocked out, a technique that is usually effective but tedious and irreversible.

15 A more sophisticated way to cover areas of a negative is to apply so-called lithographers' tape, a product in which a strongly dyed or pigmented unplasticized polyvinyl chloride (UPVC) resin composition is extruded as a 50-micrometer film and thereafter coated on one side with a normally tacky and pressure-sensitive adhesive (PSA). Although this commercially popular tape is convenient to apply, effective, and removable, it is not completely uniform in appearance, hence may raise doubts about quality and thus is less aesthetically appealing than may be desired. Further, the colorants required do not exhibit a "sharp 20 cut-off" and hence severely limit the amount of visible but lithographically inactive (non-actinic) light transmitted; this light is used by the lithographic preparator to verify that desired information has not been inadvertently covered. Additionally, the acetone or other solvent often used to clean the lithographic negative tends to dissolve the UPVC and may cause the color to leach from the film, contaminating adjacent areas and causing considerable annoyance to the printer.

25 Attempts have been made to incorporate dye in such solvent-resistant polymers as polyethylene terephthalate and polypropylene, but processing at the required high levels of dye has proved difficult and the higher extrusion temperatures tend to decompose or volatilize the dye. Those dyes that are stable at the high temperatures are very limited in the number of colors available. If the dye is incorporated in the pressure-sensitive adhesive, a residual "ghost" color image often remains on the negative when the tape is 30 removed.

Brief Description of the Invention

35 In its broadest sense, the invention provides shaped polymeric substrates including films, fibers, fabrics, mats, coatings, particles, spheroids, or even randomly shaped masses with colored coatings or markings. In a presently preferred embodiment, the present invention provides an improved lithographers' tape, possessing the advantages of prior art tapes while avoiding their disadvantages. Like the previous tapes, the tape of the invention is easily applied to a negative, readily covering flaws, blemishes, or other areas to be masked; 40 similarly, after use, it is easily removed. Unlike earlier tapes, however, the colored layer lies beneath the polymer film, so that it is resistant to solvent and its color does not leach. The appearance of this novel tape is uniform and aesthetically pleasing, it has good optical transparency in the non-actinic spectral region with a sharp cutoff, and since the color cannot migrate into the adhesive, it leaves no colored "ghost" after removal from a substrate.

45 The invention relies on a unique composition of matter that is a film-forming, essentially light-stable (i.e., remaining light-absorbing throughout the duration of its intended use and not undergoing polymerization) water-insoluble but organo-soluble salt of a polymeric sulfonate (especially a polyester sulfonate) anion and a dye cation. For convenience this salt will hereinafter be referred to as a "dye-polysalt". In one embodiment of the invention a layer of this dye-polysalt is bonded to a shaped polymeric substrate, especially a polymeric film, preferably one that is self-supporting. In another embodiment it is applied in imagewise fashion; e.g., the primary colors of cyan, magenta, and yellow, optionally including black, may be 50 applied to produce polychromatic images, which may optionally be shaded. In the presently preferred embodiment of the invention, a layer of the dye-polysalt is bonded over an entire major surface of a self-supporting polymeric film, especially a polyester film, and overcoated with a normally tacky and pressure-

sensitive adhesive, thereby yielding a lithographers' tape. For this purpose it is generally desirable for the dye-polysalt to absorb radiation having a wavelength of 250 to 1000 nm, especially 300 to 1000 nm.

5 Detailed Description

For convenience, the polymeric sulfonates and cationic dyes employed in the examples are tabulated below:

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Polymeric Sulfonates

Each of the following polymeric sulfonates is a sulfopolyester made by conventionally reacting the indicated molar amounts of diacids and diols to obtain a polymer having the sodium sulfonate equivalent 15 weight listed.

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Sulfopolyester (Polymeric Sulfonate)	SO ₃ Na Equivalent Weight	Mole Percent						Diol Polycaprolactone MW 530
		Sodium Sulfonated Isophthalic Acid	Orthophthalic Acid	Isophthalic Acid	Terephthalic Acid	Adipic Acid	Sebatic Acid	
A	2502	4.0	46	5.0	45.0	10		50
B	2962	5.0		40.0				40
C	2490	5.0		32.5				45
D	1350	7.5		42.5				50
E	1606	7.5		32.5				20
F	1430	7.5		21.5				50
G	1483	7.5		17.5				30
H	1502	7.5						25
								50

The following polymeric sulfonate, hereinafter designated "J," was made by first reacting 2 moles of 5-sodiosulfonato-isophthalic acid and 1 mole of polycaprolactone diol (MW 530) to obtain a product having a molecular weight of 1,588. 50.0 grams of this product was then reacted with 26.5 grams of polycaprolactone diol (MW 530), 14.67 grams of ethylene glycol (MW 62.1), and an excess (55.33 grams) of toluene 2,4-diisocyanate (MW 174.1). The resultant sulfonated polyurethane polymer, which had a sulfonate equivalent weight of 4,653, was dissolved in tetrahydrofuran (THF) to obtain a 49% solids solution whose sulfonate equivalent weight was 9,530.

Another polymeric sulfonate sodium salt (designated "K" herein) was a "50% active" sulfonated polystyrene having a molecular weight of 40,000, obtained from Polysciences, Ltd. under the trade designation #8365. This salt is understood to have a sodium equivalent weight of 412.

Cationic Dyes

To the extent that the information is available, these dyes will be listed below by their Chemical Abstracts System (CAS) number, Colour Index number, their generic Colour Index name, and the dye name or trade name under which they were obtained. It is to be understood that as obtained from a commercial supplier the dyes may not be full strength and may contain additional substances to enhance their rate of solution. Certain dyes were separately prepared, using procedures well known to those skilled in the art; the Colour Index name or the structural formula for the dye cation is shown in each such case.

In cases where the dye concentration is inadequately known, the equivalent weight for the dye cation present may be estimated analytically in preparing the examples. For this purpose a gravimetric procedure based on precipitation of the dye as its tetraphenylborate or perfluoro(4-ethylcyclohexane) sulfonate salt is preferred. The filter containing the water-washed and dried precipitate (as well as the walls of the precipitation vessel, to which some dye-salt may adhere) is then extracted with the least polar reagent grade organic solvent capable of efficiently removing the dye-salt, which may be recovered by evaporation and weighed.

The equivalent weight of the dye sample is given by the ratio:

$$30 \quad \frac{\text{wt. of sample} \times \text{mol. wt. of dye-salt}}{\text{wt. of dye-salt}}$$

A volumetric procedure is often practical, based on the tendency of the aforementioned precipitants to generate a colloidal suspension of the dye-salt, which coagulates at or near the stoichiometric equivalence point due to reversal of the charge on the particles. Typically the clear solution will have lost nearly all its color at the true end-point. This procedure requires no knowledge of the molecular weight of the dye cation; the equivalent weight of the dye sample is given by the ratio:

$$40 \quad \frac{\text{wt. of sample}}{\text{normality of titrant} \times \text{mL of titrant}}$$

In the absence of interfering substances, volumetrically-estimated equivalent weights normally fall within a few percent of those determined gravimetrically. In certain cases a useful, though usually less accurate, estimate of the equivalent weight of a dye sample is provided through solvent extraction by dichloromethane, ethanol or the like, followed by evaporation to dryness. This estimate is given by the ratio:

$$50 \quad \frac{\text{wt. of sample} \times \text{mol. wt. of dye}}{\text{wt. of extracted dye}}$$

In each of these ratios weights are in milligrams.

The prime reason for dye analysis is to prevent having an excess of dye. It is not by any means essential to establish exact stoichiometric equivalence between dye cations and polysalt anions; an excess of the latter is not particularly harmful. If, however, the dye cations are in excess, they will be accompanied necessarily by non-polymeric anions, and will not be held by coulombic electrical forces to the polysalt, thus will be free to diffuse out and contaminate adjacent material. Such a situation departs from the spirit of

this invention.

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Dye No.	CAS No.	Colour Index No. or Dye Cation Formula	Generic Name	Dye Name or Trade Name	Dye Equivalent Weight
1	6363-84-4	51215	Basic Black 7	--	267
2	3521-06-0	42025	Basic Blue 1	New Solid Green 3B	493
3	33203-82-6	51004	Basic Blue 3	Genacryl® Blue 3G	1160
4	61-73-4	52015	Basic Blue 9	Methylene Blue	374
5	569-64-2	42000	Basic Green 4	Malachite Green	473
6	3056-93-7	48035	Basic Orange 21	Atacryl® Orange LGM-FS	614
7	477-73-6	50240	Basic Red 2	Safranin Y	351
8	3648-36-0	48015	Basic Red 13	Atacryl® Pink G-FS	619
9	548-62-9	42555	Basic Violet 3	Crystal Violet	493
10	81-88-9	45170	Basic Violet 10	Rhodamine B	479
11	2390-54-7	49005	Basic Yellow 1	Thioflavin	393
12	4208-80-4	48055	Basic Yellow 11	Atacryl® Yellow 4G-FS	449
13	12217-50-4		Basic Yellow 13	Atacryl® Yellow L5GA	1300

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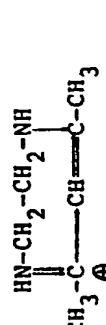
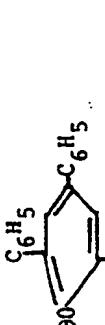
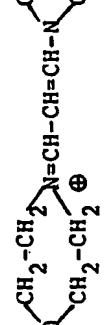
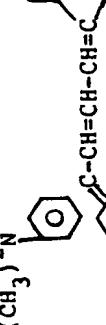
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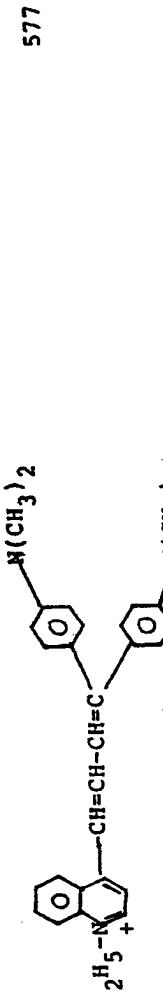
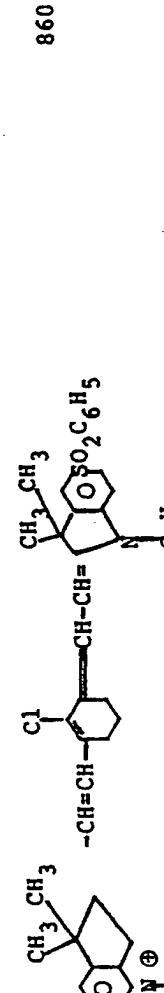
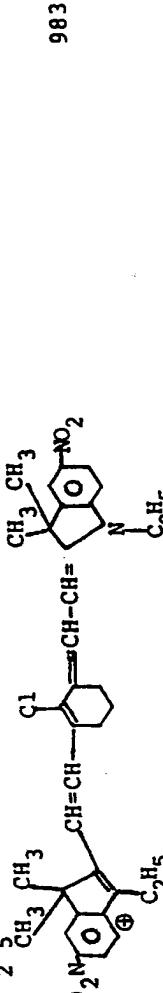
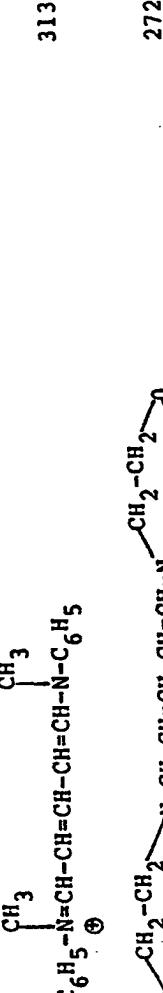
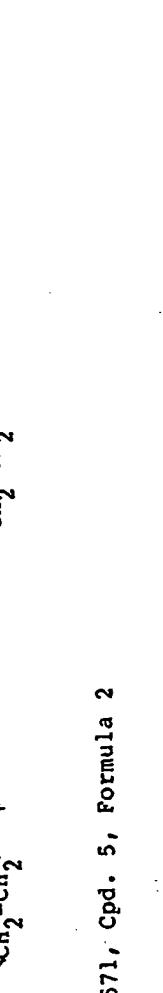
Dye No.	CAS No.	Colour Index No. and Generic Name or Dye Cation Formula	Dye Name or Trade Name	Dye Equivalent Weight
14	12270-31-4	Basic Yellow 21	Intradene® Fast Yellow 7GL	8
15	52435-14-0	Basic Yellow 24	Basacryl® Yellow 5GL	10
16	41025-67-6	Basic Yellow 25	Basacryl® Yellow 5R	12
17	54060-92-3	Basic Yellow 28	Atacryl® Yellow GA 2008	14
18	12221-86-2	Basic Yellow 40	Atacryl® Brilliant Flavine 9GFF	16
19	61951-43-7	Basic Yellow 53	Sevron® Yellow 8GMF	18
20	71838-81-8	Basic Yellow 61	Sandocryl® Brilliant Yellow B5GL	20
21	71838-82-9	Basic Yellow 63	Astrazon® Yellow 8GSL	22
22	80802-82-0	Basic Yellow 73	Cathilon® Yellow CD-RLH	24
23		$\begin{array}{c} \text{C}_2\text{H}_5 \\ \\ \text{C}_6\text{H}_5-\text{N}=\text{CH}-\text{CH}=\text{CH}-\text{N}-\text{C}_6\text{H}_5 \\ \\ \text{C}_2\text{H}_5 \end{array}$		

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Dye No.	CAS No.	Colour Index No. and Generic Name or Dye Cation Formula	Dye Name or Trade Name	Dye Equivalent Weight
24	51802-84-7	 $\text{C}_6^{\text{H}_5}-\text{N}=\text{CH}-\text{CH}=\text{CH}-\text{N}(\text{C}_6^{\text{H}_5})_2$		411
25	21995-41-5	 $\text{HN}-\text{CH}_2-\text{CH}_2-\text{NH} \quad \text{CH}_3-\text{C}=\text{CH}-\text{C}-\text{CH}_3$	5,7-dimethyl-2,3-dihydro diazepinium	160
26	40836-01-9	 $\text{C}_6^{\text{H}_5}-\text{N}=\text{CH}-\text{CH}=\text{CH}-\text{N}(\text{C}_6^{\text{H}_5})_2$	2,4,6-triphenylpyriinium(chloride)	345
27	46462-94-6	 $\text{C}_6^{\text{H}_5}-\text{N}=\text{CH}-\text{CH}=\text{CH}-\text{N}(\text{C}_6^{\text{H}_5})_2$		246
28	47827-22-5	 $\text{C}_6^{\text{H}_5}-\text{C}=\text{CH}-\text{CH}=\text{C}(\text{O})-\text{C}_6^{\text{H}_5}$		714

Dye No.	CAS No.	Colour Index No. and Generic Name or Dye Cation Formula	Dye Name or Trade Name		Dye Equivalent Weight
			5	10	
29	80989-42-0				577
30	82926-12-3				860
31	*				983
32	47164-23-8				313
33	22967-08-4				272

*U.K. Pat. App. 87-121571, Cpd. 5, Formula 2

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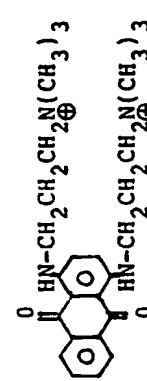
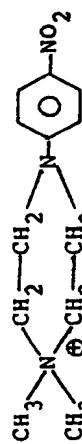
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Dye No.	CAS No.	Colour Index No. and Generic Name or Dye Cation Formula	Dye Name or Trade Name	Dye Equivalent Weight
34		$\text{O}_2\text{N}-\text{C}_6\text{H}_4-\text{NH}-\text{CH}_2-\text{CH}_2-\text{CH}_2-\text{N}(\text{CH}_3)_3$	4-(3'-trimethylammonio)propyl-nitrobenzene	365
35	78197-03-2		1,4-bis(3'-trimethylammonio-propylamino)anthraquinone	346
36			4-(4'-nitrophenyl)-1,1-dimethylpiperazinium	363
37		Red dye mix of Example 1	↳ introduce in dye claimer down to row 24	405

Example 1

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A solution of 2.49 g. sulfopolyester C (sodium salt) in 20.00 g. methanol and 77.51 g. water was mixed with the ionic equivalent amount of the chloride salt of Dye No. 4, viz., 100 ml. of 0.01 N. aqueous solution. An immediate precipitation of the dye-polysalt occurred. The mixture was then heated to 80°C. on a steam 10 bath for one hour to complete the reaction, little or no dye remaining in solution. The aqueous phase was removed by careful decantation and the solid deposit washed three times with 100-mL portions of 80°C. water for 15 min. to remove sodium chloride. The insoluble dye-polysalt, dried to constant weight in a 100°C. oven, weighed 2.7 g. A 1.0 g. portion was dissolved in 19.0 g. 1,2-dichloroethane to give an 15 intensely blue solution, which upon application to poly(ethylene terephthalate) film dried to a strongly adherent water-resistant transparent blue coating. The coated film was usable as a filter for modifying the color of incandescent or fluorescent lights, as for decorative or photographic purposes.

The term "absorbance," as used herein, is defined in the manner accepted by spectroscopists, being the common logarithm of the ratio I_0/I , where I_0 is the intensity of the incident light and I the intensity of the transmitted light; normally this is defined for a relatively narrow wavelength interval and plotted as a function 20 of wavelength. When the observed sample is a dye, there will typically be one or more wavelengths at which the absorbance passes through a maximum; such wavelengths are denoted by the symbol λ_{MAX} . A measure of the breadth of the absorbing region is provided by defining the wavelengths λ_A and λ_B , at which the sample absorbance is one-half of its value at λ_{MAX} . We define λ_A as the shorter of the two wavelengths, shorter also than λ_{MAX} . The molar extinction coefficient, ϵ , for a dye is defined as the 25 absorbance of a dye (solution) sample, divided by the molar concentration of the dye and by the light's path length, in cm., in the sample. For the purposes of this invention it is convenient to define the relative extinction coefficient, ϵ_R , as the ratio of a dye's ϵ to that for the dye methylene-blue, (Dye No. 4), observed under similar conditions. It will be apparent that a dye should be selected to have a molar extinction coefficient suitable for the desired use; for the purposes of this invention ϵ_R must be greater than about 30 0.01, and preferably at least about 0.1, at one or more wavelengths. Those skilled in the art will also recognize that the absorbance of a coating is dependent on the concentration of the dye and the thickness of the coating, and that molar extinction coefficients of two or more dyes may be directly compared when 35 they are present in the same coating and at known relative molar concentrations, provided that their absorptions do not overlap. Methylene blue having been chosen as the standard and assigned a value of $\epsilon_R = 1.00$, it is only necessary to utilize other dyes such as Dyes No. 6 and 25 as secondary standards; if, for example, a violet, blue, or green dye is to be compared. By this means it is not difficult to verify the utility of a dye for the purposes of this invention. It must not be assumed that dyes with the highest extinction coefficients will be suitable for all purposes; when less intense colors having high resistance to light-fading are required, dyes such as No. 34, 35, and 36 may be strongly preferred.

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Example 2

45 In a screw-capped 25-mL vial was placed 2.49 g. sulfopolyester C (sodium salt), 0.35 g. Dye No. 26, and 22.2 g. 1,2-dichloroethane. The mixture was heated to 70°C. (on a steam bath) until a low viscosity homogeneous solution of the dye-polysalt resulted, after which it was carefully decanted from the precipitated sodium chloride, and a portion was coated on polyester film. The transparent yellow coating, ($\lambda_A = 338$ nm, $\lambda_B = 438$ nm, $\lambda_{MAX} = 415$ nm, $\epsilon_R = 0.2$) also absorbed strongly in the near-ultraviolet, ($\lambda_{MAX} = 366$ nm, $\epsilon_R = 0.3$) and was suitable for use as an ultraviolet filter for removing the mercury 50 emission lines (at ca. $\lambda = 365$ nm) that are typically strongly present, though unwanted, in fluorescent-light illumination. As an additional benefit, the strong emission lines at ca. $\lambda = 406$ nm are also removed.

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Example 3

Following the procedure of Example 3, a 0.71-g. portion of Dye No. 28 was reacted with an ionically

equivalent amount of sulfopolyester D, (1.35 g.), and 1,2-dichloroethane (12.34 g.), to yield a deep blue solution which was separated by decantation from precipitated sodium salts and coated on polyester film. The strongly adherent and intensely blue coating had λ max = 643 nm. and also an even stronger absorption in the near-infrared region at λ max = 827 nm.

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Example 4

10 The procedure of Example 3 was repeated except that a 10% excess over the ionically equivalent amount of sulfopolyester A (2.75 g.) was used in place of sulfopolyester D, and 36.50 g. of 1,2-dichloroethane was used. The resulting deep blue solution, after filtration to remove fine particles down to about 8 micrometers, was applied to polyester film, forming a tightly-adherent water-resistant blue coating. When applied to a poly(methyl methacrylate) optical-recording disk it absorbed the incident "reading" laser 15 light of 820 nm.; however, when the solid state laser power was increased by a factor of about ten for the purpose of "writing" digital information, the heating effect of the strongly absorbed laser light was great enough to cause destruction of the dyed polymer layer and consequent removal of the dye, thus providing non-absorbing spots corresponding to the digital information being encoded, which then was immediately able to be "read" by the laser system operating in its lower power mode. Other dye-polysalts capable of 20 absorbing infra-red radiation may, of course be substituted for the dye-polysalt used in this example.

Example 5

25 Following the procedure of Example 2, seven vials, each containing 2.49 g. of sulfopolyester C and 22.2 g. of 1,2-dichloroethane, but differing in the amount of Dye No. 11, were prepared. The weights of dye varied in about equal steps from 0.39 to 0.19 g., thus providing ionic equivalent ratios, dye/sulfopolyester of 0.99, 0.91, 0.84, 0.75, 0.66 0.57 and 0.48. All went into solution, but with increasing difficulty and resulting in 30 increasingly viscous solutions, varying from watery to a thick syrup. This behavior is in accord with there being a tendency toward ion-multiplet formation when unplaced sodium cations are present but not when large dye cations predominate. The ion-multiplets bridge between different polymer chains, thus serving as labile crosslinks which cause increased viscosity. The extent of ion-multiplet formation decreases markedly at elevated temperatures. Coatings made from the lower ratio samples do, for example,, show increasing 35 tendency to swell and soften when contacted with moisture, a normally undesirable property; however, moderate departures from stoichiometry do not result in coatings having poor adhesion or other greatly inferior properties. Therefore it is not necessary to have an exact equivalent weight for the dye to be used in preparing a dye-polysalt.

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Example 6

45 In a 3.8-L (one-gallon) screw-capped glass jar were placed 429.0 g. of sulfopolyester F (0.300 molar equivalent of Na^+) and an ionically equivalent amount of cations of a mixture of dyes, namely Dye No. 25, 6.42 g. (0.040 mole); Dye No. 23, 22.70 g. (0.072 mole); Dye No. 24, 24.66 g. (0.060 mole); Dye No. 12, 27.14 g. (0.061 mole); Dye No. 6, 9.60 g. (0.016 mole); and Dye No. 8, 30.16 g. (0.049 mole), and 3000 g. of 1,2-dichloroethane. The mixture was allowed to react under agitation and gentle warming to ca. 40° C. until all polymer had dissolved. The solution was then pressure-filtered to remove all particles larger than 2 50 micrometers. A small portion of this solution was evaporated to dryness to furnish material for solubility testing, and another small portion was used for adhesion testing. The remainder was employed in the following manner to provide deeply-colored non-actinic coating film and pressure-sensitive tape.

A thin coating of the dye-polysalt solution was applied by extrusion coating to one side of a 25-micrometer biaxially oriented polyethylene terephthalate (polyester) film, which was then passed through a 55 70° C. oven to evaporate the solvent, leaving a dried red coating approximately 8 micrometers thick. The coating thus produced absorbed light strongly from 310 nm to 565 nm with an absorbance of 3.5 or more within this range, yet showed good transparency from 600 nm to longer wavelengths, the absorbance being below 0.25. This is described as "sharp cut-off" behavior; the coating is essentially opaque to actinic light

for common presensitized lithographic plates while not being optically opaque. A dilute urethane low adhesion backsize solution (cf. U.S. Pat. No. 2,532,011) was then applied to the opposite side of the film and the solvent evaporated. Next a dilute crosslinked acrylic primer solution was applied over the dye-polysalt coating and the solvent evaporated to leave a coating about 8 micrometers thick. Over the primer 5 coating was then applied a 55% solids heptane solution of a 90:10 isoocetyl acrylate:acrylic acid copolymer pressure-sensitive adhesive, and the solvent evaporated, leaving an adhesive coating about 25 micrometers thick, and providing a red-colored tape suitable for masking lithographic negatives. The fact that the thickness of the tape is less than the previously available commercial product is considered advantageous, as its lower profile is much less likely to cause handling difficulties.

10

Example 7

15 Following the procedure of Example 6, 200.3 g. of sulfopolyester F (0.140 molar equivalent of Na⁺) was reacted with Dye No. 25, 4.82 g. (0.030 mole); Dye No. 23, 9.45 g. (0.030 mole); Dye No. 24, (12.33 g. (0.030 mole), Dye No. 12, 13.57 g. (0.030 mole); and Dye No. 6, 12.00 g. (0.020 mole) in 1500 g. of 1,2-dichloroethane. The filtered solution was similarly coated on the same grade of polyester film. The coating thus produced was essentially opaque to ultraviolet and visible light from 310 nm to 515 nm, exhibiting an 20 absorbance in excess of 3.5 over that region. It showed good transparency from 540 nm to longer wavelengths, its absorbance being below 0.25. This film, and pressure-sensitive lithographic tape made therefrom by the method of Example 6, is non-actinic toward those presensitized lithographic plates that have been specially desensitized to wavelengths beyond about 500 nm in order that they may be handled under amber rather than red illumination. This is considered to be a substantial commercial advantage 25 owing to the wider optical range which allows more precise use of the tape.

26 It is presently preferred to coat the dye-polysalts from an appropriate solvent, although it might be feasible to employ a colloidal dispersion, or even a hot melt for the more heat-resistant dyes. A solution can be applied by any suitable means, e.g., roll coating curtain coating, knife coating, painting, wiping, flow coating, spraying, and the like. Determination of an organic solvent that is useful for a given dye-polysalt is 30 relatively easy, involving simple empirical experimentation.

31 For many uses, it is important that the dye-polysalt coating be well bonded to the support on which it is coated. As might be expected, the degree of adhesion of a given dye-polysalt is dependent on the specific substrate, and a dye-polysalt that adheres well to one substrate may not adhere nearly so well to another. On the other hand, a different dye-polysalt may have altogether different adhesion characteristics. The 35 degree of adhesion can be measured conveniently by using a razor blade to score six parallel lines spaced about 1 mm apart in the dried coating and then to score an additional six similarly spaced parallel lines at right angles to the first, thereby creating a crosshatched pattern of 25 squares, each approximately 1 mm on a side. A strip of acrylic pressure-sensitive adhesive tape (3M "Magic" Tape, No. 810) is pressed firmly onto the crosshatched surface, the tape aligned at about 45° to the scored lines and allowed to dwell for 40 approximately 30 seconds. The tape is then pulled away at approximately right angles to the surface, the degree of adhesion, expressed as percent, being four times the number of colored squares remaining adhered to the support. It has been found convenient to classify the degree of adhesion somewhat less precisely, as follows: "A", 100% adhesion; "B", 75-98%; and "C", less than 75%.

41 The following tabulated examples show the interrelationship of substrate and dye-polysalt on adhesion 45 values:

50

55

5	Example	Substrate	Dye-polysalt			Adhesion
			Dye	Cation No.	Polymer Polyanion	
8	8	Polystyrene sheet	8		Polyurethane sulfonate	C
10	9	Do	9		Polystyrene sulfonate	A
15	10	Do		Red polysalt mix of Example 6		C
20	11	Poly(methyl methacrylate) sheet	8		Polyurethane sulfonate	B
25	12	Do	9		Polystyrene sulfonate	A
30	13	Do		Red polysalt mix of Example 6		A
35	14	Polycarbonate	8		Polyurethane sulfonate	C
40	15	Do	9		Polystyrene sulfonate	A
45	16	Do		Red polysalt mix of Example 6		A
50	17	Styrenated Polyester	8		Polyurethane sulfonate	C
55	18	Do	9		Polystyrene sulfonate	A
	19	Do		Red polysalt mix of Example 6		B
	20	Polyimide film	8		Polyurethane sulfonate	B

21	Do	9	Polystyrene sulfonate	A
5 22	Do		Red polysalt mix of Example 6	A
10 23	Cellulose Acetate	8	Polyurethane sulfonate	C
	Film			
24	Do	9	Polystyrene sulfonate	A
15 25	Do		Red polysalt mix of Example 6	C
20 26	Polyvinyl Fluoride	8	Polyurethane sulfonate	C
	Film			
25 27	Do	9	Polystyrene sulfonate	B
28	Do		Red polysalt mix of Example 6	C
30 29	Polyvinyl Chloride	8	Polyurethane sulfonate	A
	Film			
35 30	Do	9	Polystyrene sulfonate	A
31	Do		Red polysalt mix of Example 6	A
40 32	Polyvinyl- idene chloride	8	Polyurethane sulfonate	A
	Film			
45 33	Do	9	Polystyrene sulfonate	C
34	Do		Red polysalt mix of Example 6	A

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	35	Gelatin (photographic print)	8	Polyurethane sulfonate	C
5					
	36	Do	9	Polystyrene sulfonate	A
10	37	Do		Red polysalt mix of Example 6	A
15	38	Phenol formaldehyde resin	8	Polyurethane sulfonate	C
	39	Do	9	Polystyrene sulfonate	B
20	40	Do		Red polysalt mix of Example 6	B
25	41	Melamine formaldehyde resin	8	Polyurethane sulfonate	C
30	42	Do	9	Polystyrene sulfonate	A
35	43	Do		Red polysalt mix of Example 6	C
40	44	Nylon sheet	8	Polyurethane sulfonate	C
45	45	Do	9	Polystyrene sulfonate	B
50	46	Do		Red polysalt mix of Example 6	B
	47	Acetal sheet	8	Polyurethane sulfonate	B
55	48	Do	9	Polystyrene sulfonate	A
	49	Do		Red polysalt mix of Example 6	B
50	50	Latex paint	8	Polyurethane sulfonate	B

51	Do	9	Polystyrene sulfonate	A
52	Do		Red polysalt mix of Example 6	A
53	Glossy oil paint	8	Polyurethane sulfonate	C
54	Do	9	Polystyrene sulfonate	B
55	Do		Red polysalt mix of Example 6	B
56	Polyester film	8	Polyurethane sulfonate	C
57	Do	9	Polystyrene sulfonate	C
58	Do		Red polysalt mix of Example 6	A
59	Polyurethane film	8	Polyurethane sulfonate	A
60	Do	9	Polystyrene sulfonate	B
61	Do		Red polysalt mix of Example 6	A

35 In the foregoing examples the polyurethanesulfonate dye-polysalt was dissolved in, and coated from, a mixture of tetrahydrofuran and dichloromethane. Either of these solvents or 1,2-dichloroethane, could have been used individually for this purpose. The dye-polysalts typically show good solubility, in excess of 5% by weight, in a wide variety of useful coating solvents. Thus, the polystyrene-sulfonate dye-polysalt was coated from nitromethane but has good solubility in γ -butyrolactone, dimethyl sulfoxide, and 2,2,2-trifluoroethanol; it shows fair solubility (1% or greater) in cyclopentanone, pyridine, methanol, acetonitrile, dichloromethane, 1,2-dichloroethane, and 2-methoxyethanol. The polyester sulfonate dye-polysalt for the foregoing adhesion tests was coated from 1,2-dichloroethane, but equally good adherence was achieved when the dried dye-polysalt of Example 1 was dissolved in any of the following good solvents and coated on the polyester substrate: 2,2,2-trifluoroethanol, dichloromethane, cyclopentanone, tetrahydrofuran, nitromethane, γ -butyrolactone, warm glacial acetic acid, warm propylene carbonate, 1,4-dioxane, dimethyl sulfoxide, chloroform, or 1,1,2-trichloroethane. Fair solubility (1% or greater) is shown in acetone, acetonitrile, propylene dichloride, o-dichlorobenzene, 2-methoxyethyl acetate, and methyl or ethyl iodide.

40 In the following examples, dye-polysalts were formed by reacting the cationic dye indicated with sulfopolyester C, following the procedure of Example 2, and coating the resulting solutions on polyester film. Successful coatings were obtained in each case.

<u>Example</u>	Dye No.	A	B	MAX	R
62	2	593	677	645	1.2
5 63	3	594	677	658	
10 64	4	572	692	667	[1.00]
15 65	5	584	663	632	1.0
20 66	6	455	525	508	0.7
25 67	8	476	580	545	0.6
30 68	9	520	632	590	1.3
35 69	10	524	585	563	1.3
40					
45					
50					
55					

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	70	11	390	455	426	0.5
5	71	12	387	465	426	0.6
	72	13	385	470	426	
10	73	14	394	461	424	0.9
	74	18	408	465	440	
15	75	21	403	474	435	
	76	22	397	494	452	
20	77	23	317	383	347	0.6
	78	24	360	430	391	0.5
25	79	25	<310	338	321	0.3
	80	27	<310	335	319	0.3
30	81	28		(643	0.3	
				(827	1.0	
35	82	29	513	703	617	
40	83	30	786	852	805	3.6
45	84	31	748	864	820	1.8
	85	32	424	498	456	
50	86	34	352	418	384	0.3
	87	35		(596	0.1	
55				(644	0.1	

88	36	365	0.2
6			
89	37	<310	585

10 The following dyes were used with sulfopolyester D:

90	4
15	6
91	8
92	11
93	12
20	28
94	
95	

25 The following dyes were used with sulfopolyester A

96	6			
30	7			
97	8			
98	12			
99	15			
35	378	477	430	
100	16	402	505	465
101	17	410	505	455
102	18	408	465	440
103	20			
40	104			
105	28			
106	33	395	445	

45 The following dyes were used with sulfopolyester B:

50	107	28	
	108	37	
		<310	585

The following dye was used with sulfopolyester E:

109 37 <310 585

5

The following dyes were used with sulfopolyester F:

110 1 <310 700

111 6

112 8

113 12

114 23

115 24

116 25

20

The following dye mixture was used with sulfopolyester G:

117 37 <310 585

The following dye mixture was used with sulfopolyester H:

118 37 <310 585

35

Example 119

Preparation of Dye No. 23. In a 750 mL Erlenmeyer flask fitted with an air condenser were placed 121.1 g. (1.00 mole) of N-ethylaniline, 82.2 g. (0.50 mole) of 1,1,3,3-tetramethoxypropane, 51.0 g. (0.51 mole) of concentrated hydrochloric acid, and 100.0 g. of ethyl acetate. The reaction flask was heated on a steam bath for 18 hours, after which the volatile constituents were evaporated off, leaving 177 g. of red oil. To this oil was added 350 g. acetone, causing crystallization to occur after a short time, and the mixture was allowed to ripen for ca. 18 hours. The crystals were then filtered off and washed with about 1000 g. of acetone, until the filtrate was pale pink. There was recovered 100.34 g. pinkish crystals, m.p. 158°-160° (64% yield) of the chloride salt of Dye No. 23.

Examples 120 and 121 describe the preparation of a unique class of nitroaniline dyes bearing quaternary ammonium groups, suitable for preparing dye-polysalts for use in the practice of the invention.

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Example 120

Preparation of Dye No. 34. In a 125 mL flask were mixed 14.11 g. (0.10 mole) of 4-fluoronitrobenzene, 10.22 g. (0.10 mole) of 3-(dimethylamino) propylamine and 5.00 g. (0.12 mole) of dry sodium fluoride. Upon warming, a reaction began, and after an hour the mixture was heated to 150° C. for an hour. The mixture was cooled below 100° and treated with 400 mL water containing 0.10 mole sodium hydroxide at 60° C. for one hour; it was then chilled to solidify the freed amine and the aqueous phase was decanted off. After

three water washings and drying, the crude product was dissolved in methyl tertiary butyl ether, filtered and evaporated to dryness, giving 19.69 g. (88% yield) of N-(3-dimethylaminopropyl) 4-nitroaniline, m.p. 60° - 61.5° C. A 2.23 g. (0.01 mole) portion of this product was dissolved in 15 mL of acetone and treated with 2.13 g. (0.015 mole) of methyl iodide in a closed vessel. There was an immediate reaction and presently a 5 yellow solid was suddenly precipitated. The mixture was warmed for 1/2 hour at 50° C. cooled, filtered, washed with acetone, and dried; the remaining solid, weighing 3.31 g., m.p. 210° - 211.5° C., represented a 90% yield of Dye No. 34.

10

Example 121

Preparation of Dye No. 36. In a 250 mL flask were mixed 28.22 g. (0.20 mole) of 4-fluoronitrobenzene, 20.04 g. (0.20 mole) of N-methylpiperazine, and 8.40 g. (0.20 mole) of dry sodium fluoride. There was a 15 spontaneous reaction, the temperature rising to about 100° C.; the mixture was heated to 150° C. for one hour and then cooled and treated with 150 mL hot water containing 0.20 mole of sodium hydroxide to liberate the amine. A yellow precipitate formed, and most of the aqueous phase was decanted; 60 g. of hot 20 chlorobenzene was added, and the solution was washed with three portions of hot water and allowed to crystallize upon cooling. The crude product, 40.54 g., m.p. 103° - 105° C., was dissolved in 180 mL hot ethanol and treated with 3.00 g. active carbon; the mixture was filtered, washed with 50 mL hot ethanol, and on cooling deposited yellow crystals, 24.36 g., m.p. 105° - 106° C. The filtrate was treated with 4.00 g. active carbon, filtered and boiled down to 60 mL; on cooling, an additional 15.00 g. of product, m.p. 105° - 25 106° C., was recovered; the total yield of N-methyl-N'-(4-nitrophenyl) piperazine was 89%. A portion of this amine (2.21 g., or 0.01 mole), dissolved in 15 mL acetone, was treated with 2.84 g. (0.02 mole) methyl iodide in a closed vessel. An immediate reaction occurred; the mixture was then warmed to 60° C. for 1/2 hour and cooled. The precipitate was washed three times with acetone; when dried it weighed 3.55 g., the 30 yield being 98%. It was dissolved in 70 mL hot water and on cooling crystallized to give 1.01 g., m.p. 257° - 259°, of purified Dye No. 36. From the filtrate an additional 2.22 g. of dye was recovered.

Although numerous examples of the invention have been provided, it should not be presumed that the 35 list of either dyes or sulfonated polymers is exhaustive. Among the many other useful dyes are the following: 15000-59-6, 11052, Basic Blue 54; 61901-59-5, 11056, Basic Orange 24; 12221-38-4, 11075, Basic Blue 66; 12221-37-3, 11076, Basic Blue 65; 14097-03-1, 11085, Basic Red 18; 12270-13-2, 11154, Basic Blue 41; 36904-42-4, 11175, Basic Orange 25; 12221-39-5, 11185, Basic Blue 67; 42373-03-6, 11460, Basic Red 29; 12221-63-5, 11465, Basic Red 39; 4443-99-6, 11825, Basic Black 2; 4569-88-4, 12210, Basic Blue 16; 26381-41-9, 12250, Basic Brown 16; 71134-97-9, 12251, Basic Brown 17; 68391-31-1, 12719, Basic Yellow 57; 39393-39-0, 45174, Basic Violet 11; 55798-23-7, 48100, Basic Yellow 23; 68123-13-7, 56059, Basic Blue 99; 633-03-4, 42040, Basic Green 1; 2185-87-7, 42563, Basic Blue 8; 2390-60-5, 42595, Basic Blue 7; 2185-86-6, 44040, Basic Blue 11; 4692-38-0, 44085, Basic Blue 15; 989-38-8, 45160, Basic Red 1; 2390-63-8, 45175, Basic Violet 11; 6359-45-1, 48013, Basic Violet 16; 6441-82-3, 48020, Basic Violet 7; 4657-00-5, 48040, Basic Orange 22; 4208-81-5, 48065, Basic Yellow 12; 6320-14-5, 48070, Basic Red 12; 4468-98-8, 50055, Basic Violet 6; 6411-47-8, 50250, Basic Red 10; 2381-85-3, 51182, Basic Blue 12; 4517-26-4, 51190, Basic Blue 10; 2679-01-8, 52020, Basic Green 5; 2391-29-9, 52025, Basic Blue 25; 12217-41-3, 61512, Basic Blue 22. (In the foregoing listing, the first number is the CAS number, and the second is the Colour Index number; the dye is further identified by its C.I. name.)

45 Among the many other usable sulfonated polymers are copolymers of sodium-4-sulfonatostyrene, sodium-(2-sulfonatoethyl)acrylate, sodium-(2-sulfonatoethyl) methacrylate, and especially polyesters of the same compositions as "A" through "H" above but in which the sodium-5-sulfonato isophthalic acid is partially or completely replaced by sodium-sulfonatosuccinic acid, sodium-sulfonatonaphthalene-2,6-dicarboxylic acid, or sodium sulfonatonaphthalene-1,8-dicarboxylic acid.

50 For practical reasons of synthesis, it is generally preferred that the cation equivalent weight of the polyesters should be at least about 1000, whereas such is not the case with vinyl polymers. In all cases, a cation equivalent weight of about 5.000 represents a reasonable upper limit, beyond which the amount of dye that can be incorporated is extremely small.

55 It will likewise be appreciated that, while the sodium salts are presently preferred because of their relatively low cost and generally good solubility in water, lithium, potassium, or ammonium salts (or mixtures thereof) could also be used in preparing the dye-polysalts.

Claims

1. A film-forming essentially light-stable salt of a sulfonated polymer and a cationic dye.
2. The salt of claim 1 wherein the sulfonated polymer is a sulfonated polyester.
- 5 3. The salt of claim 2 wherein the sulfonated polyester is the esterification product of at least one organic diol and at least two dicarboxylic acids, at least one of said acids being monosulfonated and the total of sulfonated components being present in sufficient amount to yield, in the sodium salt form, a sulfonate equivalent weight from about 1,000 to about 5,000.
4. An article comprising a substrate coated with at least one salt according to claim 1.
- 10 5. The article of claim 4 wherein the substrate is a transparent self-supporting polymeric film.
6. The article of claim 8 wherein the film comprises biaxially oriented polyethylene terephthalate.
7. The article of any preceding claim wherein the salt is overcoated with a layer of adhesive.
8. The article of claim 7 wherein the sulfonated polyester is the esterification product of at least one organic diol and at least two dicarboxylic acids, at least one of said acids being monosulfonated and the total of sulfonated components being present in sufficient amount to yield, in the sodium salt form, a sulfonate equivalent weight from about 1,000 to about 5,000.
- 15 9. The article of claim 7 wherein more than one salt is employed, selected so as to yield either a red or an amber color that blocks all ultraviolet actinic radiation.
10. A nitroaniline dye bearing a quaternary ammonium group, suitable for use in preparing the salt of claim 1.

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DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)		
A	EP-A-0 180 402 (TOYO SODA MANUFACTURING CO.,LTD.,) * page 2, line 30 - line 33 ** page 3, line 20 - line 35 @ page 5, line 19 - page 6, line 12 * - - -	1	C 09 B 69/06 G 03 F 1/00		
A	EP-A-0 153 736 (E.I. DU PONT DE NEMOURS AND COMPANY) * page 6, line 25 - line 35 ** page 7, line 27 - page 8, line 6 * - - -	1			
A	EP-A-0 130 789 (TOYO SODA MANUFACTURING CO., LTD.,) * page 3, line 1 - line 10 ** page 7, line 29 - page 8, line 19 @ page 12, line 31 - line 38 * - - -	1			
A	DE-A-3 524 197 (TOYO SODA MANUFACTURING CO., LTD.,) * page 8, line 9 - line 21 ** page 15, line 17 - line 24 * - - - -	1			
TECHNICAL FIELDS SEARCHED (Int. Cl.5)					
C 09 B G 03 F C 08 F					
The present search report has been drawn up for all claims					
Place of search	Date of completion of search	Examiner			
The Hague	12 September 91	MONTERO LOPEZ B.			
CATEGORY OF CITED DOCUMENTS					
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T: theory or principle underlying the invention					

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